



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4894-3

Job Sheet 172988



Part No: D4894-3

Job Qty: 4 ea

Part Name: Aft Beam



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/23/18

Job Tracking No:

Due Date: 3/5/18

Created By: Logan David

Type: Stock

Description:

Note: DWG REV B SHEET 2 IPP REV:B 13.05.27 AS PER DWG REV.A DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		3/2/18	0.00	0.00	Start Up Waterjet		DE 18/03/27
100	Waterjet	4 pcs		3/3/18	0.00	10.87	Waterjet1		DE 18/03/27
110	QC	4 pcs		3/3/18	0.00	0.00	QC2 Waterjet-1		DE 18/03/27
114	Mill Conv	4 pcs		3/3/18	0.00	5.13	Mill Conv 1		J.C.V.
116	QC	4 pcs		3/3/18	0.00	0.00	QC2 Machining-3		J.C.V. 18-04-09
120	QC	4 pcs		3/3/18	0.00	0.00	QC8 Machining-3		18/04/27
130	HandFinish	4 pcs		3/3/18	0.00	1.01	HandFinish1		18-04-25
140	QC	4 pcs		3/3/18	0.00	0.00	QC7-4		18-04-05
141	Powdercoat	4 pcs		3/5/18	0.00	0.67	Powdercoat1		18-04-25
142	QC	4 pcs		3/5/18	0.00	0.00	QC3		19 APR 27 2018
145	QC	4 pcs		3/5/18	0.00	0.00	QC5		9-89
150	Packaging	4 pcs		3/5/18	0.00	0.00	Packaging3-2		APR 27 2018
160	QC21-SA	4 Ea		3/5/18	0.00	0.00	QC21		6 9-89

Part Op 100 - 1-Cut as per Dwg Dwg Rev: _____ Prog Rev: _____ 2-Debur if necessary

Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB

114 - DRILL HOLES AS PER DWG

116 - QC2- Inspect parts off machine FAI/FAIB

120 - QC8- Inspect parts - second check

130 - Chemical Conversion Coat per QSI005 4.1

140 - QC7-Inspect Chemical Conversion Coat

141 - White Gloss(Ref 4.3.5.1) per QSI005 4.3-Alum MASK AS PER NOTE 8 START TIME: 2:45 OVEN

TEMPERATURE: 320° FINISH TIME: 3:15 M 158760

142 - QC3- Inspect Part Finish

145 - QC5- Inspect part completeness to step on W/O

150 - Identify as per dwg & Stock Location: _____

160 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.000X06.000	6061T6 Bar 1.00 X 6.00	18.3400 ft (4.585 ea)	90-Start up Operation	



Container No: S055677



Part: D4894-3

Job No: 172988

Serial No/Batch: S055677

Revision:

Inspector:

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Date: 03/27/18

BA-1
11
477
3
18

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B1.000X06.000	18	44	0
Part Specifications				
Specifications could not be found.				

Plex 2/23/18 1:14 PM dart.logan.david

DART AEROSPACE LTD		Work Order:	172988
Description: Aft Beam		Part Number:	D4894-3
Inspection Dwg: D4894	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
55.02	+/-0.030	55.02	✓			
19.63	+/-0.030	19.63	✓			
7.38	+/-0.030	7.38	✓			
10.61	+/-0.030	10.61	✓			
5.25	+/-0.030	5.25	✓			
8.25	+/-0.030	8.25	✓			
1.50	+/-0.030	1.50	✓			
3.50	+/-0.030	3.50	✓			
0.65	+/-0.030	0.65	✓			
9.56	+/-0.030	9.56	✓			
4.65	+/-0.030	4.65	✓			
28.80	+/-0.030	28.80	✓			
7.16	+/-0.030	7.16	✓			
4.47	+/-0.030	4.47	✓			
1.00	+/-0.030	1.00	✓			
3.50	+/-0.030	3.50	✓			
0.75	+/-0.030	0.75	✓		Caliper	306.08
1.800 Pitch	+/-0.005	1.800	✓			
3.600	+/-0.005	3.600	✓			
0.60	+/-0.030	0.600	✓			
2.300	+/-0.005	2.300	✓			
Ø0.377	+0.006/-0.001	0.377	✓			
2.00	+/-0.030	2.000	✓			
0.60	+/-0.030	0.600	✓			
Ø0.129	+0.005/-0.001	0.129	✓			

Measured by:	SCV	Audited by:	SCV	Preliminary Approval:	
Date:	18/04/24	Date:	18/04/24	Date:	
Rev	Date	Change	Revised by	Approved	
A	14.11.13	New Issue	KJ		

